

Work Order ID 154595

Thursday, December 15, 2016 1:33:58 PM

154595

Ship JAN 6

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Item ID: D3822-1KIV Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Vertical Tunnel, LH-Ivory
Start Date: 12/12/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/15/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: **DEC 15 2016** Tooling: _____ Date: _____ Run Start ***NR1***
QC: **DAS 21** Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3822	Rev. C								DAS 07 9-89
100		0.00							
100									
HandThermo	Memo	0.01							
Hand Finishing Thermoforming	1-Cut Sheet to required Blank size								16/12/20
105		0.00							DAS 07 9-89
105	Dry Material								
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Dry Sheet as per QSI022 KYDEX								16/12/20
	Temp: 150 deg. F								
	Time IN: 5:00 PM								
	Time OUT: 6:00 AM								

DEC 20 2016

Per.....

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N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 12/12/2016 **Start Qty:** 1.00

1

Customer:

Required Date: 12/15/2016 **Req'd Qty:** 1.00

1

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Insp.
Stam

0.00

1 10

0.07

Thermoform

Thermoforming Machine

Memo

1-Machine Set-Up

2-Pre-heat Tool to required temp.

3-Thermoform as per Dwg and Folio #FTA025 using tool DT9073

Dwg Rev: 

Folio Rev: 3

Visually inspect for proper formation of each part

140

0.00

140

0.30

HandThermo

Hand Finishing Thermoforming

Memo

1-Trim to finished dimensions as per Dwg

DAS
07
9-89

16/12/21

Page 3

Packaging

1

①

1

16-12-72

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amp
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9
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DAS
6
9-8.9

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-89		
180									
QC	Memo	0.02							
Quality Control									

DAS
21
9-89

JAN 03 2017

Picklist Print

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Work Order ID: 154595

154595

Parent Item: D3822-1KIV

D3822-1KIV

Parent Item Name: Vertical Tunnel, LH-Ivory

Start Date: 12/12/2016

Required Date: 12/15/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

IPP Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-62015		Purchased		No		100	sf	1,738.890	7.8	7.803902			DAS 07 9-89

MKYD6185S 080-P3-62015

Kydex Ivory (52"x96"-.080)

Location	Loc Qty	Loc Code
SHED	728	
m129761	347	
m130671	381	
therm	1010.89	
121755	13.44	
124462	997.45	

16/12/20

7.81 sg ft

DART AEROSPACE LTD		Work Order: 154595
Description: Vertical Tunnel, LH		Part Number: D3822-1KIV/KGY
Inspection Dwg: D3822	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

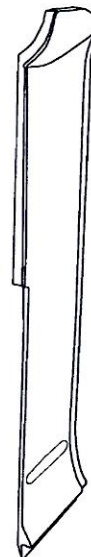
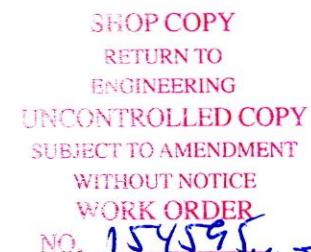
Measured by: DAS 07 9-89 Date: 16/12/20

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.8	Min	0.87"	✓			
0.3	Min	0.40"	✓			
0.55	Min	0.60"	✓			
0.040	Min	0.046"	✓			
0.050	Min	0.074"	✓			

Measured by: DAS 07 9-89 Date: 16/12/21
Audited by: 9 Date: 16-12-22
Prototype Approval: 9-89 N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	



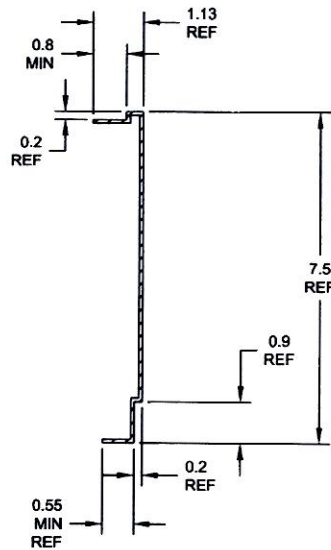
RELEASE
09/03/12 MP

NOTES:

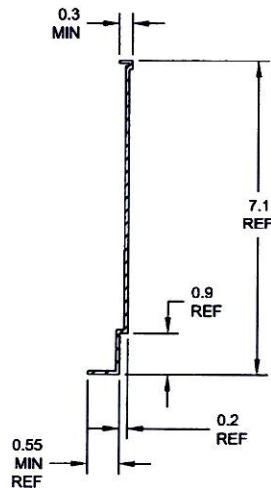
- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9073 PER DART QSI 022. TRIM PER MOLD.
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3822-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

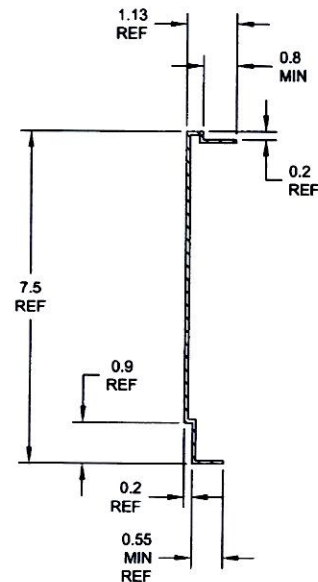
C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N'S D3822-1-2/3-5/7(KIV) AND ADD STEEL GRAY P/N'S D3822-1-2/3-5/7(KGY) (ZN A5-1, A5-2, A5-4, A5-5, A5-6)	PH	09.05.05
B	37.8 WAS 38.8 (ZN C8-4); MODIFY TOP OF -3 AND ADD VIEW J (ZN A4-3); INCREASE JOGGLE ON -3 (ZN C8-4); UPDATE VIEW F (ZN A1-4); REASON: TO IMPROVE FIT OF D206-781-151 KIT	PH	09.02.09
A	NEW ISSUE	PH	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		DRAWING NO. D3822 TITLE VERTICAL TUNNEL (BELL 206 A/B) REV. C SHEET 1 OF 1 SCALE NT	
DATE	09.05.05	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



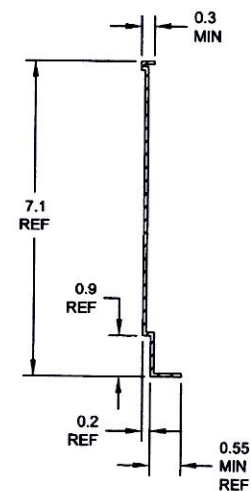
SECTION A-A C6-1



SECTION B-B C6-1



SECTION C-C C4-2



SECTION D-D C4-2

RELEASED
09/05/05

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3822	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		VERTICAL TUNNEL (BELL 206 A/B)	NTS
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